

Classifications

EN ISO 17633-B:2010 : TS 308H-F C1/M21 1
 JIS Z 3323-2007 : TS308H-FB1

AWS A5.22-2012 : E308HT1-1/4

Description

- K-308HT is designed for MAG welding of high carbon 18%Cr-8%Ni stainless steels(STS 304H, 307H) and recommended to be used for high temperature service (about 600°C)
- It is a titania type of flux cored wire for all-position welding and has excellent feedability and increased creep resistance at elevated temperature.
- The weld metal contains optimum ferrite contents in their austenitic micro structures and their weldability is excellent with lower crack susceptibility.

Welding positions**Polarity & shielding gas**

- CO₂: 100% CO₂ (15~25ℓ/min)
- Mix: Ar+20% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO ₂	0.06	0.65	1.00	19.50	10.50	7.5
Mix	0.06	0.75	1.10	19.80	10.50	8.0

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -40°C	Remarks
AWS A5.22		min. 520	min. 35		
EN ISO 17633-B		min. 520	min. 30		
Example	430	600	39	45	CO ₂
	440	610	40	55	Mix

Notes on usage and welding condition

- Refer to page 313 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat inp

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		

Approvals

JIS

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.